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COUNTRY Poland

REPORT

SUBJECT Metal Products Factory at Krasnik

DATE DISTR.

21 MAY 1958

Planned production of bearings & 100mm
artillery shell cases - including description
of factory manufacturing above items; manpower,
production data, markings of bearings

PAGES

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REFERENCES

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SOURCE EVALUATIONS ARE DEFINITIVE. APPRAISAL OF CONTENT IS TENTATIVE.

1. The metal products factory at Krasnik (N 50-55, E 22-14) made solely ball and roller bearings until 1952, when the production of 85-millimeter anti-tank and anti-aircraft shell cases was introduced. In 1957, 4,000,000 bearings of 120 types were made, although it was originally planned that 140 types should be produced; the number of bearings produced fulfilled the plan. For 1958, it was planned to produce 4,200,000 bearings and to introduce the production of 100-millimeter artillery shell cases. In the first half of 1958 the figure of 20,000 complete 85-millimeter anti-tank shells, minus charge, is to be reached, following a reorganization of production.

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2. [redacted] a report on the Krasnik factory which lists the identification numbers and types of bearings produced, describes the leading personnel, and gives details on the physical lay-out of the plant. It includes a sketch of the plant lay-out.

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ECONOMICBuciska Metal Products Factory at KRASNIK1. History of the factory.

- a) The metal products factory at KRASNIK originated from a small factory making bearings, which was built in 1938.
- b) A year after the war, in 1946 it was considerably enlarged and 90% of the equipment is of Soviet origin

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c) Up to 1952, the factory continued to make ball and roller bearings, but since then, war production has been introduced, consisting of anti-tank and anti-aircraft shell cases, 85 mm. At the same time, production of bearings was increased, and was intended to reach 140 types in 1957. In 1958, production of 100 mm. artillery shell cases is to be introduced, and the programme is to expand to include further types in 1960. According to the plan for 1957, 4,000,000 bearings were to be made, and the figure of 4,200,000 was to be reached in 1958.

2. Location (see sketch map).

a) The factory is 9 km. North-west of KRASNIK, on the East side of the KRASNIK - BUDZYN - URZEDOW road, about 400 m. from it, and 3 km. from the Southern outskirts of URZEDOW.

b) A new factory railway track branches off from KRASNIK station and runs alongside the road. A new housing estate has been built opposite the factory on the West side of the road.

c) The area covered by the factory is about 1,000 x 1,400 m. with a wide space for expansion of the East side; it is surrounded by a wire fence, and the main entrance is on the KRASNIK - URZEDOW road.

3. Production

a) Bearings: In 1957, the figure of 4,000,000 was reached, and 120 types were made, but this is, as stated, to be increased in 1958. Production is however not high enough to cover Poland's requirements and she has to import construction of a similar factory in POZNAN was therefore

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started in 1957, and production is to begin there in 1960. The bearings made at this factory have the trade mark F.L.T. (Fabryka Lozynsk Technol) and their actual number.

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1a) Ball bearings.

6202, 6203, 6204, 6205, 6206, 6207, 6208, 6209, 6210, 6211, 6213, 6214, 6215, 6216.

6303, 6304, 6305, 6306, 6307, 6308, 6309, 6310, 6311, 6312, 6314, 6315, 6316, 6317, 6318, 6320, 6322, 6324, 6326.

2a) Double thrust? ball bearings.

One type only: 3308

3a) Cone bearings

30204, 30205, 30206, 30207, 30208, 30209, 30210, 30211, 30212, 30213, 30215, 30216, 30217, 30218.

32205, 32206, 32207, 32208, 32209, 32210, 32212, 32213, 32214, 32215, 32216, 32217, 32218.

4a) Roller bearings

NU-204, NU-205, NU-206, NU-207, NU-208, NU-220, NJ-204, NJ-205, NJ-206, NJ-207.

5a) Axial bearings

51207, 51208, 51209, 51211, 51212, 51217, 51218, 51220, 51222, 51210, 52204, 52205, 52206, 52207, 52208, 52209, 52210, 52211, 52212, 52218, 52220, 52222.

6a) Bearings for military production.

Axial: 51209, 52211, 52209, 52222.

Ball bearings: 6313, 6316, 6317, 6318.

Cone bearings: 32216, 32217, 30216, 30218.

These bearings are inspected and taken over by a military group permanently at the factory, and are intended for the aircraft industry and for tanks.

The factory is the largest in Poland making bearings. Another factory in Warsaw, on ul Duchnicka, went into production in 1956, but in 1957 it was only making 6 types, some prepared in the KRASNIK factory. There is another factory in Poznan, but its production is not large.

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b) Military production

- 1b) Complete anti-tank shell, minus charge, etc. 85 mm. After reorganisation of 25X1 production, the figure of 20,000 is to be reached in the first half of 1958.
- 2b) 100 mm. artillery shells, to be made at the beginning of 1958.
- 3b) 85 mm. anti-aircraft shell cases, to be made in 1958.

c) Other products.

The factory also makes small metal parts such as axles for horse-drawn vehicles, discs, etc., and semi-finished products for the ball-bearings factory in Warsaw.

4. Supplies of Material.

Most of the steel comes from the HUTA STALOWA WOLA foundries and from foundries in Upper Silesia, mainly the BATORY, CHOZOWIC and BAILDON, KATOWICE. Materials are brought by rail.

5. Destination of products.

- a) The bearings for military requirements are delivered to the SWIDNIK aircraft factory, at LUBLIN, and to the tank factory at LABEDY, and others.
- b) In addition to home requirements, bearings are exported to Hungary, Roumania and Bulgaria.
- c) The products are taken away by rail.

6. Employees

- a) The actual number of employees at the factory is difficult to estimate, as there is considerable fluctuation. It varies between 2,000 and 3,000 working three shifts. The pay is fairly high, compared with other factories, and with the building of the new housing estate, living conditions are good.
- b) One serious problem for the factory is the recruitment of skilled labour, which is non-existent. The works tries to train new apprentices and spends large sums on re-training and raising the standard of skill of the workers.
- c) In the early years, there were large numbers of Soviet technicians at the factory, where production is based on Soviet technology, but there are now very few there.

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7. Personalities

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a) Manager: Ing. Brunon BILSKI, age [redacted]

b) Technical manager: Ing. Edmund JOSEFIK, [redacted]

c) Production manager: Ing. Leszek CEDLER, [redacted]

d) Director of financial administration: SWIECKI, [redacted]

e) Head of Tool Shop: Henryk ROGUSLAWSKI, technician, [redacted]

f) Head of UB section: Stefan KASMASINSKI, [redacted]

g) Chairman of party organisation: ZAWYCHTA, 3nu, [redacted]

8. LAYOUT of the factory (see plan).

- 1) Main production hall for ball and roller bearings, a masonry building 60 x 40 m. also containing department W-11. It has 10 Soviet automatic lathes, type 1262 M. for ball or roller bearings 40 mm. in diameter, 15 German PITT.LER automatic lathes for up to 50 mm. diameter, and 12 Russian 1262 P automatic lathes for diameters of over 50 mm., 30 IK-36 Soviet turret lathes, BLANCHARD grinders, and K-116 cutters for marking bearings. Dept. W-11 has about 150 machine tools. Other departments in the building include W-12, tempering shop, with 16 tempering furnaces; W-13, hard grinding, with 18 [redacted], and LZ-8, LZ-9, LZ-10, LZ-26 and LZ-27, as well as grinders for other operations, such as SMART, 3263, ORI, ORN (also for rests), in all about 160 machines. Department W-14, the ball-making section, is in the Western part of the hall where are two DR-7 Soviet machines for larger types, one CRB-5, machine for smaller types, and five more for small types; two [redacted] tempering furnaces and about 50 Soviet MAZ-32 and MAZ-33 grinders. The cones and rollers are ground on Soviet 3180 grinders, of which there are about 12, and there is one German W.M.W. grinder, tolerance up to 0.002 mm; also a file-cutting section with two Russian MAZ-50 machines, and

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about 45 drums for production of balls and rollers. The whole section contains about 160 machines and other necessary equipment. Next to Dept. W-14, there is a repair workshop, equipped with 8 W-23 lathes, 2 universal milling machines, three grinders, etc.; about 135 people work here. The hall also contains an assembling section, W-19, with 18 presses from 10 to 40 tons, and next to it, the military checking section, from which the assembled bearings go to despatch. 25X1

- 2) Technical laboratory, masonry, 20 x 12 m., where research on bearings is carried out.
- 3) Boiler-house, a fairly old masonry building on the South side of the hall and South of the railway line, 14 x 14 m.
4. Main repair shop and production of shell cases, in a masonry hall 70 x 40 m. Military production is concentrated in the Northern part of the hall, where production of 85 mm. anti-tank and anti-aircraft shells began in 1956, with its own tempering shop, for military production only, equipped with 6 furnaces and built for the planned increase in production. The entire production is carried out in accordance with Russian technological methods. The military section is known as W-17. The Southern part of the hall is Dept. W-22, the main repair shop, electrical workshop, auxiliary stores etc., with a tool room and small tempering shop; the department has about 110 machines. The building also contains Dept. W-15, the moulding shop, with 4 TUS 200 presses.
5. Construction section, planning section, part of the tool shop, technological section etc., in a fairly old masonry building, 50 x 40 m., which also contains a mechanical workshop equipped with about 150 Soviet machines. The tool room a section of which is in this building, works mainly on military production, consisting of deliveries of bearings for the SWIDNIK aircraft factory; the tool room also makes dies and blades for lathes, etc., for the whole factory.
- 6) New tool room construction of which was begun in 1956, a ferro-concrete structure faced with brick, 60 x 50 m. with a concrete roof, and lit by skylights; the entire tool section, Dept. W-21, was to be moved into this building in spring 1958.
- 7) Production of cone bearings, in a fairly old hall 90 x 50 m.; the machinery

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part of which was moved here from Hall No. 1, was set up in 1957, and 25X1
production was to begin in 1958. Further military production is to be
moved into part of this hall, and new electrical installation was being
carried out for this purpose.

- 8) Store for military production, a new masonry building 100 x 60 m., the
North side of which is one-storeyed and contains a store for reserve
machines.
- 9) New forge, Dept. W-10, preparing raw material for bearing production. The
entire equipment is of Soviet origin, and the yearly capacity which has been
laid down is 4 million bearings, to reach which an annex (b) has been
built, 40 x 30 m., to extend the forge, which is itself 110 x 30 m. The
entire working is fully automatic and there are two 400 ton presses which
process bearings 35 mm. in diameter, for the Warsaw bearings factory on
ul Dushnicka.
- 10) Compressor shop for forge, a masonry building 25 x 20 m. with four
M.A.W.G. Hungarian compressors.
- 11) Cooling tower, 18 m. high and 8 m. in diameter, a steel structure.
- 12) Store for oil, lubricants and paint, etc., a new masonry building 40 x 20 m.
with a laundry in the basement.
- 13) Telephone exchange, main electrical switch-board and works kitchen, in a
wooden hut about 35 x 10 m.
- 14) New hall, 100 x 40 m., finished in 1957, into which Dept. W-14 is to have
moved from hall No. 1. On the West side there is to be an automatic
cutting shop for material (b) to which a railway track is to lead.
- 15) Temporary structure used as a cutting shop.
- 16) Sheet metal shop and small forge, in a fairly old masonry building which
is to be equipped with new forging tools in 1958, to enable a production
rate of 20,000 anti-tank shells to be reached half-yearly.
- 17) New storage building, 70 x 18 m., divided into two parts; in the Western
part (b) finished products, including bearings, rings, etc. are to be
stored, and in the Eastern part, working materials (a).
- 18) Older storage building, 40 x 16 m., used for steel material for ball and
roller production.
- 19) New repair shop, a ferro-concrete structure, with two five-ton cranes, to be

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used for repairs to factory machinery; the repairs section in building No. 4 is to move here.

- 20) Joiner's shop and store for building materials, in a fairly old building 40 x 16 m.
- 21) Artillery shell case production, calibre 100 mm., in a fairly old masonry hall 90 x 50 m., where turret and automatic lathes had been installed in two lines in Autumn 1957; production was to start at the beginning of 1958. At the same time, production of anti-tank shells is to be moved here from hall 4(b); for the first half year, the planned production rate is 20,000 85 mm. shells. This building also contains Dept. W-18, for making axles for horse-drawn vehicles, length 1050 mm. 1150 mm., and 1250 mm.; the discs have rubber rims 16", and 20". Auxiliary Dept. W-11, in this hall, is equipped with 18 IK-36 lathes for machining ball-bearings (rotary paths).
- 22) Sanding shop, a wooden hut, on the South side of (21).
- 23) New compressor shop, equipped in Autumn 1957 and built when military production was introduced at the works.
- 24) Cooling tower for the compressor shop, a wooden structure.
- 25) Hall which has been rebuilt for exclusively military production 80 x 60 m., with about 100 presses, for moulding shell cases, in the Eastern part (a), a new tempering shop in the centre (b), with 16 tempering furnaces. The Western part of the hall was being modified in Autumn 1957 and cranes were being installed to speed up unloading from trucks (c).
- 26) Transformer station.
- 27) Railway engine shed and store for batteries for factory transport, a masonry building 14 x 14 m.
- 28) Store for oil, used for heating furnaces, in a new masonry building at the end of the railway line.
- 29) Fire fighting equipment and garage, a fairly old masonry building 25 x 10 m. with four STRA 20 fire engines, and a permanent fire guard.
- 30) Garage for factory vehicles, a fairly old masonry building 22 x 8 m.
- 31) Factory management building, T-shaped, 80 x 14 and 40 x 15 m., two-storeyed.
- 32) Apprentices' training school, one-storeyed building 40 x 12 m., near the main entrance.
- 33) New electrical heating apparatus, construction of which was begun in 1957; it was to go into operation in the second half of 1958.

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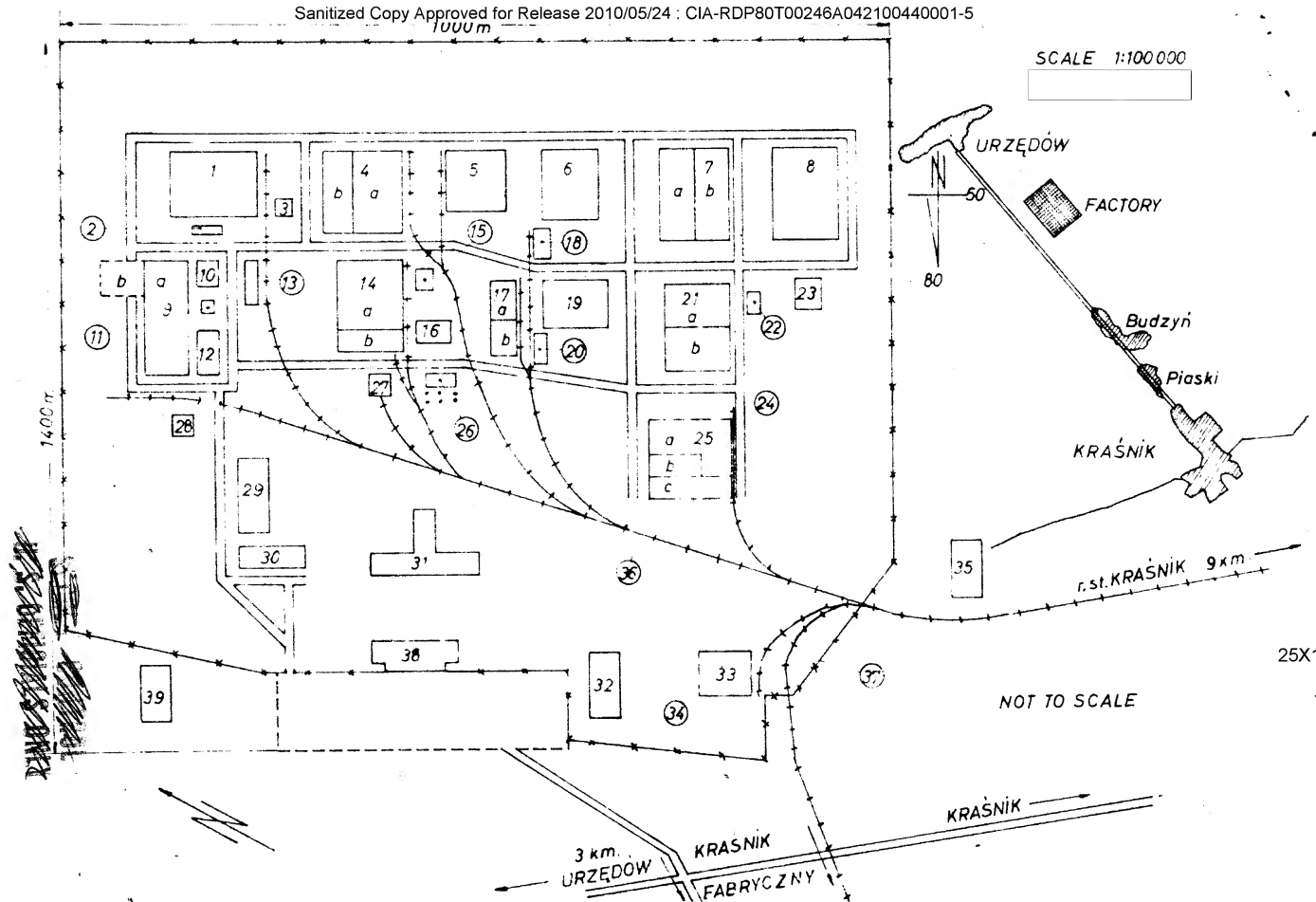
- 34) Ceiling tower, 12 m. in height and diameter. 25X1
- 35) High tension switchgear, in a masonry building 25 x 12 m. and 6 m. high, near the railway line.
- 36) Railway line branching into several tracks inside the factory area; it leads to KRASNIK station.
- 37) Fencing, wire on concrete posts, 2.80 m. high.
- 38) Main porter's office, a one-storeyed building also containing the works surgery and main guard post.
- 39) Waiting room for workmen coming from surrounding villages outside the factory area.

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